



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

**D4785-115**  
**Job Sheet 170056**



Part No: D4785-115

Job Qty: 4 ea

Part Name: Rib Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/8/18

Job Tracking No:

Due Date: 1/12/18

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG REV B SHEET 6 IPP REV:A 13.03.14 NEW ISSUE VERF:JLM IPP REV:B 13.06.21 DWG REV.B DD  
VERF:JFS

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation          | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off      |
|-------|--------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|---------------|
|       |                    |       |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |               |
| 90    | Start up Operation | 4 Ea  |            | 1/11/18  | 0.00      | 0.00    | Start Up Large Fab-6  |           | D.M.L 18-1-10 |
| 100   | Large Fab          | 4 pcs |            | 1/12/18  | 0.00      | 0.75    | Large Fab 8           |           | D.M.L 18-1-10 |
| 105   | QC                 | 4 pcs |            | 1/12/18  | 0.00      | 0.00    | QC5 QCS               |           | PD 18-01-11   |
| 107   | Large Fab          | 4 pcs |            | 1/12/18  | 0.00      | 0.00    | Large Fab 1           |           | EL 18-1-12    |
| 110   | QC                 | 4 pcs |            | 1/12/18  | 0.00      | 0.00    | QC5                   |           | PD 18-01-12   |
| 120   | QC                 | 4 pcs |            | 1/12/18  | 0.00      | 0.00    | QC10                  |           | PD 18-01-12   |
| 130   | Packaging          | 4 pcs |            | 1/12/18  | 0.00      | 0.00    | Packaging3 Large Fab  |           | D.M.L 18-1-12 |
| 140   | QC21-SA            | 4 Ea  |            | 1/12/18  | 0.00      | 0.00    | QC21                  |           |               |

Part Op 100 - 1- Pick D4306-1 and drill and chamfer hole as per dwg D4785 using DT9921

Descriptions: 107 - 1- Use DT10159 for placing and tacking bushing, remove before welding. 2- Weld bushing as per dwg D4785 3- Grind welds flush

130 - LOCATION: WA004

### Job Allocations

| Operation             | Component Part  | Required | Inventory | Allocated | Std Qty |
|-----------------------|-----------------|----------|-----------|-----------|---------|
| 90-Start up Operation | D4306-1 5015498 | 4        | 9         | 0         | 0       |
| 107-Large Fab         | D3759-1 5014816 | 8        | 106       | 0         | 0       |

### Part Specifications

Specifications could not be found.

Plex 1/8/18 3:44 PM dart.poulin.mario

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

| Work Order: _____<br><br><b>Dart Aerospace Ltd.</b><br>1270 Aberdeen Street<br>Hawkesbury, ON K64 1K7<br>CANADA<br>TEL.: 1 613 632-5200<br>Email: sales@dartaero.com<br>www.dartaerospace.com                                                                          | <b>DISPOSITION</b><br><br><div style="border: 1px solid black; padding: 5px; margin: 10px auto; width: 80%;"> <b>Mfg Date: 01/10/18</b><br/> <b>Job No: 170056</b> </div> | <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <th colspan="5" style="text-align: left;">AGAINST DEPARTMENT/PROCESS</th> </tr> <tr> <td style="width: 15%;">ork <input type="checkbox"/></td> <td style="width: 15%;">Skid-tube <input type="checkbox"/></td> <td style="width: 15%;">Cross tube <input type="checkbox"/></td> <td style="width: 15%;">Water Jet <input type="checkbox"/></td> <td style="width: 15%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>ap <input type="checkbox"/></td> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>is <input type="checkbox"/></td> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>ed <input type="checkbox"/></td> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                | AGAINST DEPARTMENT/PROCESS                                                                                                              |                                           |                                           |                                           |                                 | ork <input type="checkbox"/>           | Skid-tube <input type="checkbox"/>          | Cross tube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/>          | ap <input type="checkbox"/>                   | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/>      | Prod. Eng. Coord. <input type="checkbox"/>                 | Quality <input type="checkbox"/>            | is <input type="checkbox"/>                | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/>       | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/>       | ed <input type="checkbox"/>      | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/>     | Supplier <input type="checkbox"/>   |                                 |                                                          |                                       |                                  |                                      |                                                |                                           |
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| AGAINST DEPARTMENT/PROCESS                                                                                                                                                                                                                                             |                                                                                                                                                                           |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                                                                                                                                         |                                           |                                           |                                           |                                 |                                        |                                             |                                     |                                    |                                               |                                               |                                    |                                         |                                                            |                                             |                                            |                                        |                                          |                                              |                                      |                                  |                                    |                                        |                                     |                                 |                                                          |                                       |                                  |                                      |                                                |                                           |
| ork <input type="checkbox"/>                                                                                                                                                                                                                                           | Skid-tube <input type="checkbox"/>                                                                                                                                        | Cross tube <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | Water Jet <input type="checkbox"/>                                                                                                      | Engineering <input type="checkbox"/>      |                                           |                                           |                                 |                                        |                                             |                                     |                                    |                                               |                                               |                                    |                                         |                                                            |                                             |                                            |                                        |                                          |                                              |                                      |                                  |                                    |                                        |                                     |                                 |                                                          |                                       |                                  |                                      |                                                |                                           |
| ap <input type="checkbox"/>                                                                                                                                                                                                                                            | Machining <input type="checkbox"/>                                                                                                                                        | Small Fab <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | Prod. Eng. Coord. <input type="checkbox"/>                                                                                              | Quality <input type="checkbox"/>          |                                           |                                           |                                 |                                        |                                             |                                     |                                    |                                               |                                               |                                    |                                         |                                                            |                                             |                                            |                                        |                                          |                                              |                                      |                                  |                                    |                                        |                                     |                                 |                                                          |                                       |                                  |                                      |                                                |                                           |
| is <input type="checkbox"/>                                                                                                                                                                                                                                            | Thermoforming <input type="checkbox"/>                                                                                                                                    | Finishing <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | Rec/Store/Packaging <input type="checkbox"/>                                                                                            | Other <input type="checkbox"/>            |                                           |                                           |                                 |                                        |                                             |                                     |                                    |                                               |                                               |                                    |                                         |                                                            |                                             |                                            |                                        |                                          |                                              |                                      |                                  |                                    |                                        |                                     |                                 |                                                          |                                       |                                  |                                      |                                                |                                           |
| ed <input type="checkbox"/>                                                                                                                                                                                                                                            | Large Fab <input type="checkbox"/>                                                                                                                                        | Composite <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | Supplier <input type="checkbox"/>                                                                                                       |                                           |                                           |                                           |                                 |                                        |                                             |                                     |                                    |                                               |                                               |                                    |                                         |                                                            |                                             |                                            |                                        |                                          |                                              |                                      |                                  |                                    |                                        |                                     |                                 |                                                          |                                       |                                  |                                      |                                                |                                           |
|                                                                                                                                                                                                                                                                        |                                                                                                                                                                           | QTY Effective : _____<br><br><b>Disposition</b><br><br><div style="height: 200px; border: 1px solid black;"></div>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | MRB (QSI042) Approval<br><br>Completed By<br><br>Lead hand / Supervisor<br>Approval Verification<br><br>QC / QA Coordinator<br>Approval |                                           |                                           |                                           |                                 |                                        |                                             |                                     |                                    |                                               |                                               |                                    |                                         |                                                            |                                             |                                            |                                        |                                          |                                              |                                      |                                  |                                    |                                        |                                     |                                 |                                                          |                                       |                                  |                                      |                                                |                                           |
| <div style="display: flex; justify-content: space-between;"> <div> <b>D4785 - 115</b><br/><br/> <b>Start up Operation</b> </div> <div style="border: 1px solid black; padding: 5px; width: 150px;"> <b>Mfg Date: 01/10/18</b><br/> <b>Job No: 170056</b> </div> </div> |                                                                                                                                                                           | <b>FAULT CATEGORY</b> <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 33%;"><input type="checkbox"/> Temperature/Cure</td> <td style="width: 33%;"><input type="checkbox"/> Power Loss/Surge</td> <td style="width: 33%;"><input type="checkbox"/> Positioned Wrong</td> </tr> <tr> <td><input type="checkbox"/> Set-up</td> <td><input type="checkbox"/> Folio/Program</td> <td><input type="checkbox"/> Outside Dimensions</td> </tr> <tr> <td><input type="checkbox"/> BOM/Route</td> <td><input type="checkbox"/> Grain</td> <td><input type="checkbox"/> Over/Under tolerance</td> </tr> <tr> <td><input type="checkbox"/> Broken/Damage/Defect</td> <td><input type="checkbox"/> Weld</td> <td><input type="checkbox"/> Part Incorrect</td> </tr> <tr> <td><input type="checkbox"/> Inspection Incomplete/Unqualified</td> <td><input type="checkbox"/> Wrong Stock Pulled</td> <td><input type="checkbox"/> Part Lost/Missing</td> </tr> <tr> <td><input type="checkbox"/> Contamination</td> <td><input type="checkbox"/> Out of Sequence</td> <td><input type="checkbox"/> Part Moved</td> </tr> <tr> <td><input type="checkbox"/> Countersink</td> <td><input type="checkbox"/> Off-set</td> <td><input type="checkbox"/> Drawing</td> </tr> <tr> <td><input type="checkbox"/> Cut Too Short</td> <td><input type="checkbox"/> Mislabeled</td> <td><input type="checkbox"/> Finish</td> </tr> <tr> <td><input type="checkbox"/> Instructions Incomplete/Unclear</td> <td><input type="checkbox"/> Fit/Function</td> <td><input type="checkbox"/> Misread</td> </tr> <tr> <td><input type="checkbox"/> Drill Holes</td> <td><input type="checkbox"/> Misaligned/off center</td> <td><input type="checkbox"/> Turning Sequence</td> </tr> </table> |                                                                                                                                         | <input type="checkbox"/> Temperature/Cure | <input type="checkbox"/> Power Loss/Surge | <input type="checkbox"/> Positioned Wrong | <input type="checkbox"/> Set-up | <input type="checkbox"/> Folio/Program | <input type="checkbox"/> Outside Dimensions | <input type="checkbox"/> BOM/Route  | <input type="checkbox"/> Grain     | <input type="checkbox"/> Over/Under tolerance | <input type="checkbox"/> Broken/Damage/Defect | <input type="checkbox"/> Weld      | <input type="checkbox"/> Part Incorrect | <input type="checkbox"/> Inspection Incomplete/Unqualified | <input type="checkbox"/> Wrong Stock Pulled | <input type="checkbox"/> Part Lost/Missing | <input type="checkbox"/> Contamination | <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Part Moved          | <input type="checkbox"/> Countersink | <input type="checkbox"/> Off-set | <input type="checkbox"/> Drawing   | <input type="checkbox"/> Cut Too Short | <input type="checkbox"/> Mislabeled | <input type="checkbox"/> Finish | <input type="checkbox"/> Instructions Incomplete/Unclear | <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Misread | <input type="checkbox"/> Drill Holes | <input type="checkbox"/> Misaligned/off center | <input type="checkbox"/> Turning Sequence |
| <input type="checkbox"/> Temperature/Cure                                                                                                                                                                                                                              | <input type="checkbox"/> Power Loss/Surge                                                                                                                                 | <input type="checkbox"/> Positioned Wrong                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                                                                                                                                         |                                           |                                           |                                           |                                 |                                        |                                             |                                     |                                    |                                               |                                               |                                    |                                         |                                                            |                                             |                                            |                                        |                                          |                                              |                                      |                                  |                                    |                                        |                                     |                                 |                                                          |                                       |                                  |                                      |                                                |                                           |
| <input type="checkbox"/> Set-up                                                                                                                                                                                                                                        | <input type="checkbox"/> Folio/Program                                                                                                                                    | <input type="checkbox"/> Outside Dimensions                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                                                                                                                                         |                                           |                                           |                                           |                                 |                                        |                                             |                                     |                                    |                                               |                                               |                                    |                                         |                                                            |                                             |                                            |                                        |                                          |                                              |                                      |                                  |                                    |                                        |                                     |                                 |                                                          |                                       |                                  |                                      |                                                |                                           |
| <input type="checkbox"/> BOM/Route                                                                                                                                                                                                                                     | <input type="checkbox"/> Grain                                                                                                                                            | <input type="checkbox"/> Over/Under tolerance                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                         |                                           |                                           |                                           |                                 |                                        |                                             |                                     |                                    |                                               |                                               |                                    |                                         |                                                            |                                             |                                            |                                        |                                          |                                              |                                      |                                  |                                    |                                        |                                     |                                 |                                                          |                                       |                                  |                                      |                                                |                                           |
| <input type="checkbox"/> Broken/Damage/Defect                                                                                                                                                                                                                          | <input type="checkbox"/> Weld                                                                                                                                             | <input type="checkbox"/> Part Incorrect                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                                                                                                                         |                                           |                                           |                                           |                                 |                                        |                                             |                                     |                                    |                                               |                                               |                                    |                                         |                                                            |                                             |                                            |                                        |                                          |                                              |                                      |                                  |                                    |                                        |                                     |                                 |                                                          |                                       |                                  |                                      |                                                |                                           |
| <input type="checkbox"/> Inspection Incomplete/Unqualified                                                                                                                                                                                                             | <input type="checkbox"/> Wrong Stock Pulled                                                                                                                               | <input type="checkbox"/> Part Lost/Missing                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                                                                                                                         |                                           |                                           |                                           |                                 |                                        |                                             |                                     |                                    |                                               |                                               |                                    |                                         |                                                            |                                             |                                            |                                        |                                          |                                              |                                      |                                  |                                    |                                        |                                     |                                 |                                                          |                                       |                                  |                                      |                                                |                                           |
| <input type="checkbox"/> Contamination                                                                                                                                                                                                                                 | <input type="checkbox"/> Out of Sequence                                                                                                                                  | <input type="checkbox"/> Part Moved                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                                                                                                                         |                                           |                                           |                                           |                                 |                                        |                                             |                                     |                                    |                                               |                                               |                                    |                                         |                                                            |                                             |                                            |                                        |                                          |                                              |                                      |                                  |                                    |                                        |                                     |                                 |                                                          |                                       |                                  |                                      |                                                |                                           |
| <input type="checkbox"/> Countersink                                                                                                                                                                                                                                   | <input type="checkbox"/> Off-set                                                                                                                                          | <input type="checkbox"/> Drawing                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                                                                                                                         |                                           |                                           |                                           |                                 |                                        |                                             |                                     |                                    |                                               |                                               |                                    |                                         |                                                            |                                             |                                            |                                        |                                          |                                              |                                      |                                  |                                    |                                        |                                     |                                 |                                                          |                                       |                                  |                                      |                                                |                                           |
| <input type="checkbox"/> Cut Too Short                                                                                                                                                                                                                                 | <input type="checkbox"/> Mislabeled                                                                                                                                       | <input type="checkbox"/> Finish                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                                                                                                                                         |                                           |                                           |                                           |                                 |                                        |                                             |                                     |                                    |                                               |                                               |                                    |                                         |                                                            |                                             |                                            |                                        |                                          |                                              |                                      |                                  |                                    |                                        |                                     |                                 |                                                          |                                       |                                  |                                      |                                                |                                           |
| <input type="checkbox"/> Instructions Incomplete/Unclear                                                                                                                                                                                                               | <input type="checkbox"/> Fit/Function                                                                                                                                     | <input type="checkbox"/> Misread                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                                                                                                                         |                                           |                                           |                                           |                                 |                                        |                                             |                                     |                                    |                                               |                                               |                                    |                                         |                                                            |                                             |                                            |                                        |                                          |                                              |                                      |                                  |                                    |                                        |                                     |                                 |                                                          |                                       |                                  |                                      |                                                |                                           |
| <input type="checkbox"/> Drill Holes                                                                                                                                                                                                                                   | <input type="checkbox"/> Misaligned/off center                                                                                                                            | <input type="checkbox"/> Turning Sequence                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                                                                                                                                         |                                           |                                           |                                           |                                 |                                        |                                             |                                     |                                    |                                               |                                               |                                    |                                         |                                                            |                                             |                                            |                                        |                                          |                                              |                                      |                                  |                                    |                                        |                                     |                                 |                                                          |                                       |                                  |                                      |                                                |                                           |
| <div style="display: flex; justify-content: space-between;"> <div> <b>DART AEROSPACE</b><br/> <b>S031094</b><br/> <b>Rib Assembly</b> </div> <div> <b>PART NO:</b><br/> <b>Revision:</b><br/> <b>Operation:</b><br/> <b>Change No:</b> </div> </div>                   |                                                                                                                                                                           | OTHER : _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                         |                                           |                                           |                                           |                                 |                                        |                                             |                                     |                                    |                                               |                                               |                                    |                                         |                                                            |                                             |                                            |                                        |                                          |                                              |                                      |                                  |                                    |                                        |                                     |                                 |                                                          |                                       |                                  |                                      |                                                |                                           |